

# Work Order ID 57064

March 19, 2010 9:57:23 AM



Page 1

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 19/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 8.00



Customer:

Reference:

*10.03.19.*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3911

A

100

0.00



Bandsaw

0.00

Jeaspa Bandsaw

Memo

Cut blank to 2.885" long

*G.A 10/03/23*

*8 0*

110

0.00



HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA917 & dwg,

FOLIO REV: *B*

DWG REV: *A*

2-Deburr as required

*G.A 10/03/27*

*8 0*

# Work Order ID 57064

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Page 2

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 19/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

S.A 10/03/27

8

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S.A 10/03/29

8

0

Quality Control

140

Identify as per dwg & Stock Location: 092

0.00



Packaging

Memo

0.00

Packaging

14/3/30 (8)

# Picklist Print

March 19, 2010 9:57:23 AM

Page 1

Work Order ID: 57064



Parent Item: D3911-3

Parent Item Name: Aft Eyebolt Receiver

Start Date: 19/03/2010

Required Date: 25/03/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	11.3516	2.1895			
303 BAR 2" X 1.750"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113310

11.35157895

11.3515789

~~1.9723~~ <sup>ft</sup>  
2.1895

H.A 10/03/23

DART AEROSPACE LTD		Work Order: 57064
Description: AFT EYEBOLT RECEIVER		Part Number: D3911-3
Inspection Dwg: D3911 Rev: A		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

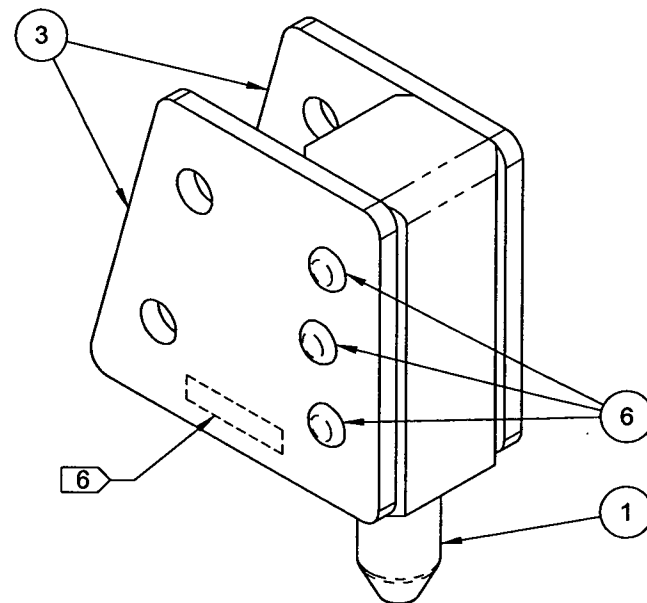
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/- .010	1.253	✓			
1.71	+/- .030	1.711	✓			REF
1.250	+/- .010	1.253	✓			
0.230	+/- .010	0.230	✓			
0.625	+/- .010	0.625	✓			REF
0.50	+/- .030	0.499	✓			
0.125	+/- .010	0.125	✓			
1.00	+/- .030	1.000	✓			
0.500	+/- .010	0.502	✓			
0.250	+/- .010	0.250	✓			REF
R0.13	+/- .030	R0.130	✓			
Ø0.129	+0.005/- .001	Ø0.130	✓			
R0.19	+/- .030	R0.190	✓			
0.960	+/- .010	0.962	✓			
0.09 x 45°	+/- .030	0.100 x 45°	✓			
Ø0.75	+ .010/- .010	Ø0.750	✓			
0.540	+/- .010	0.541	✓			
0.920	+/- .010	0.920	✓			
0.500	+/- .010	0.500	✓			
1.000	+/- .010	1.000	✓			
2.76	+/- .030	2.760	✓			REF
0.800	+/- .010	0.801	✓			
0.225	+/- .010	0.225	✓			

Measured by: B.A	Audited by: S	Prototype Approval:	N/A
Date: 10/03/27	Date: 10/03/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



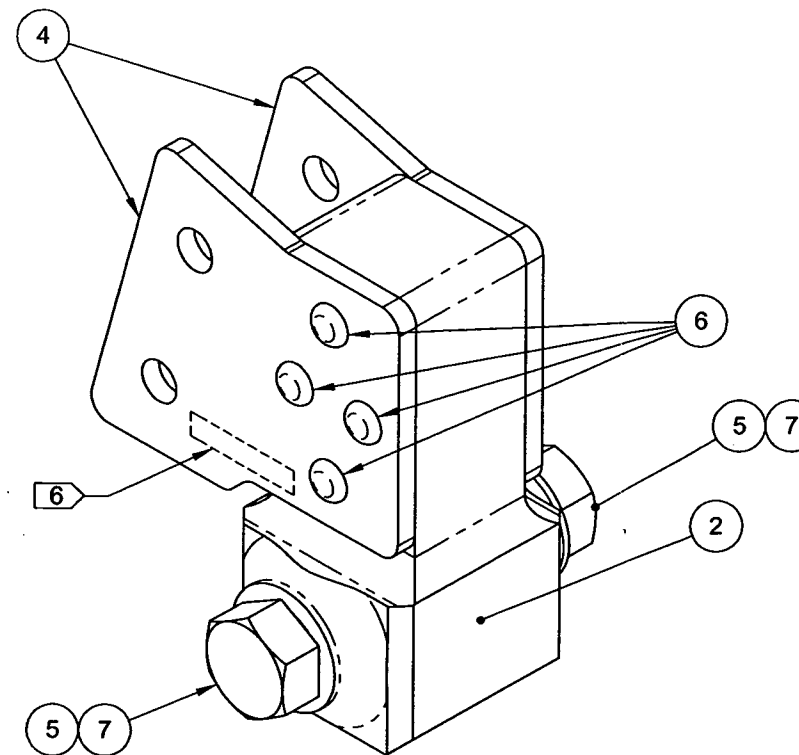
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5		2	D4087-1	CAP SCREW, PLASTIC, 3/8"X16
6	3	4	MS20615-4M20	RIVET
7		2	MS21209-C610	HELICAL



**D3911-041 BASKET INSTL STUD ASSY (LOWER)**

**NOTES:**

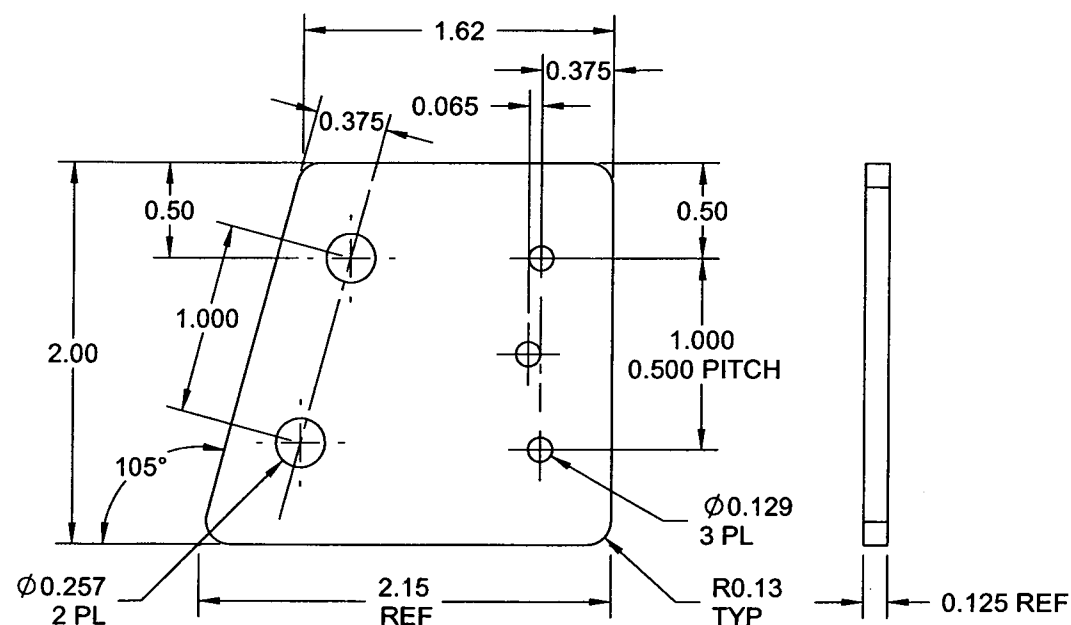
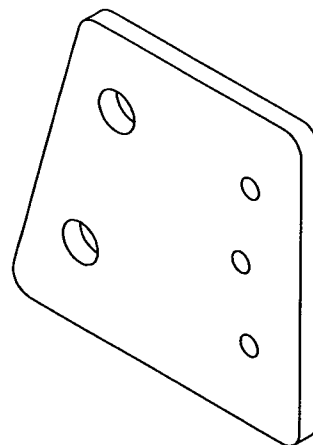
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs  
-043: 1.17 lbs



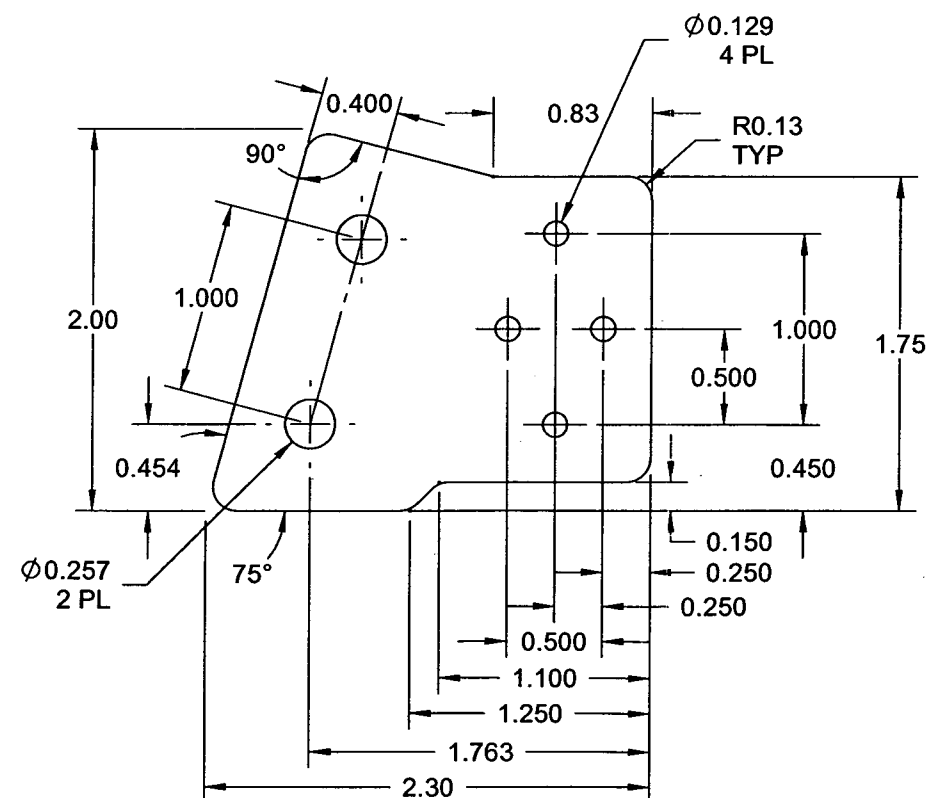
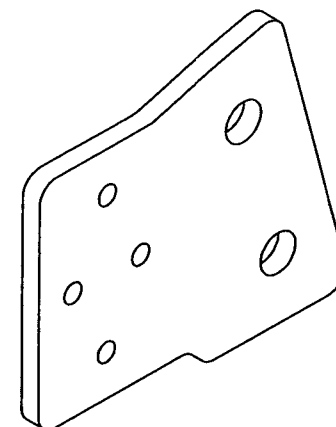
**D3911-043 AFT EYEBOLT RECEIVER ASSY**

**RELEASED**  
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3911	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3911-5 BASKET STUD PLATE**



**D3911-7 BASKET PLATE-EYEBOLT RECEIVER**

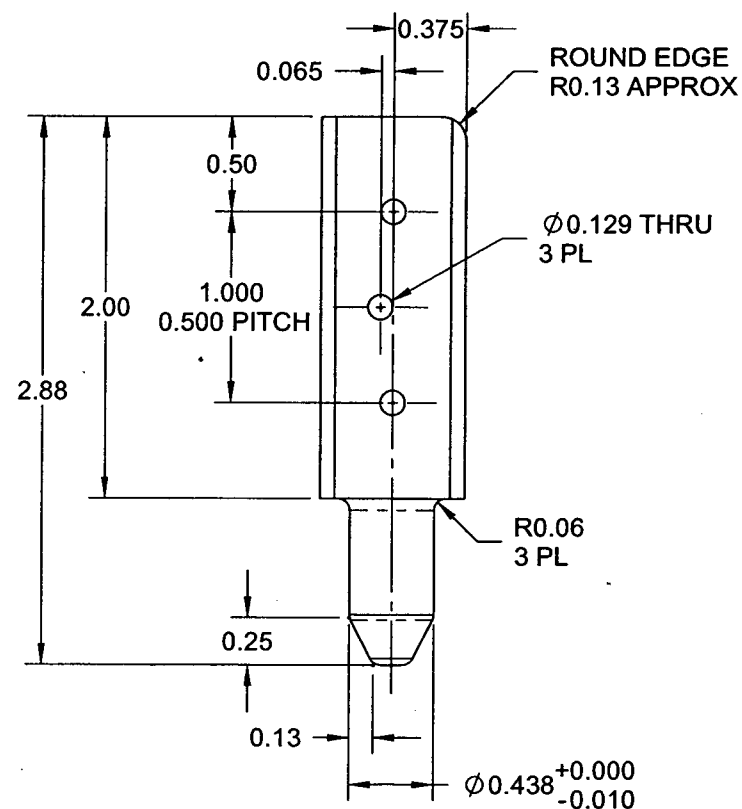
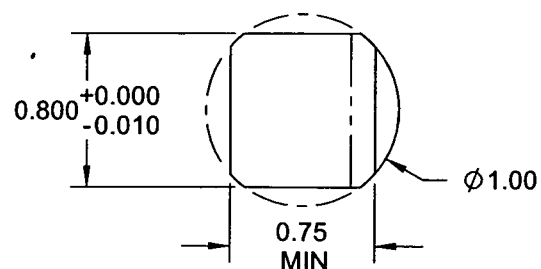
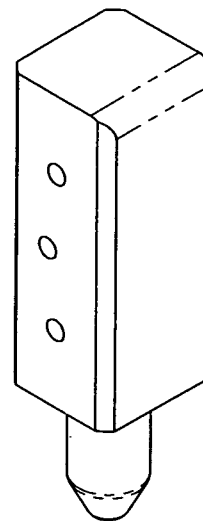
**NOTES:**

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs  
-7: 0.13 lbs

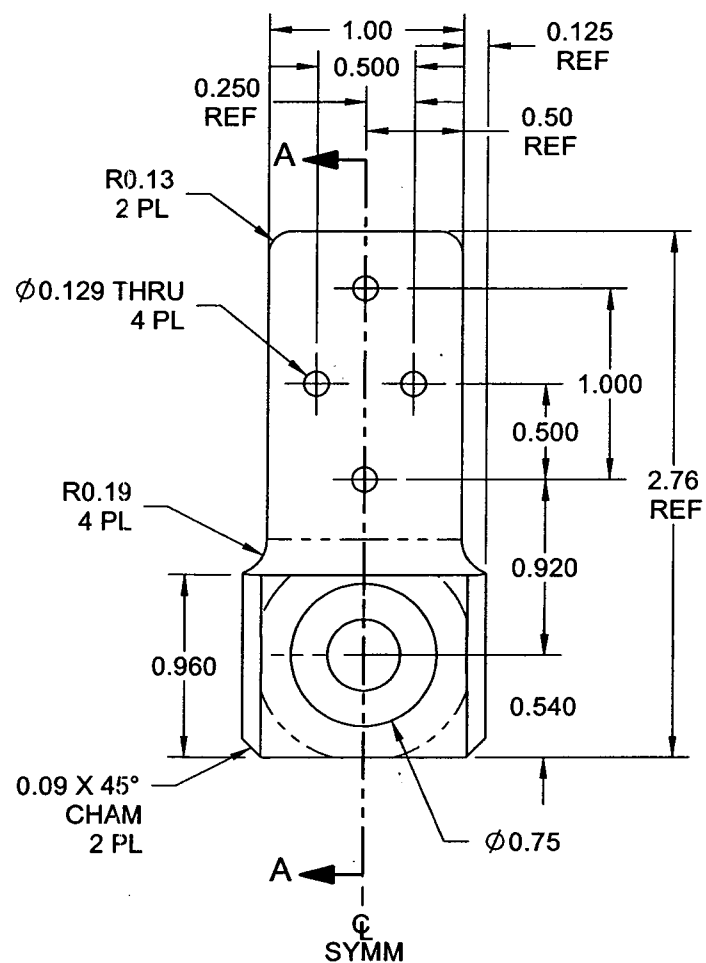
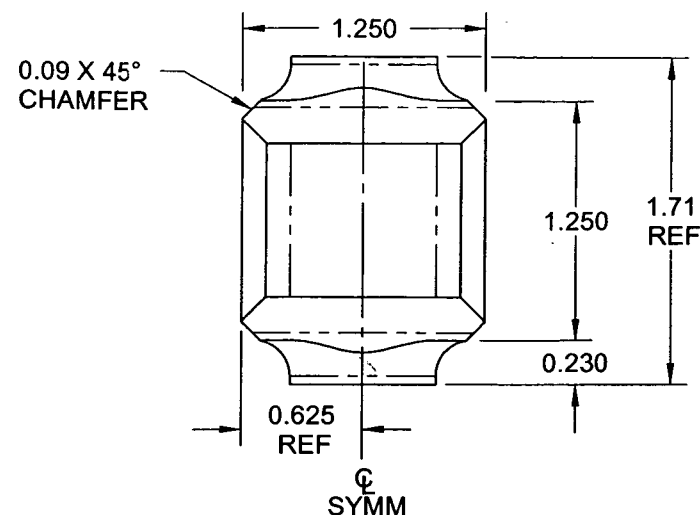
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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3911	SHEET 3 OF 3
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2010-03-12

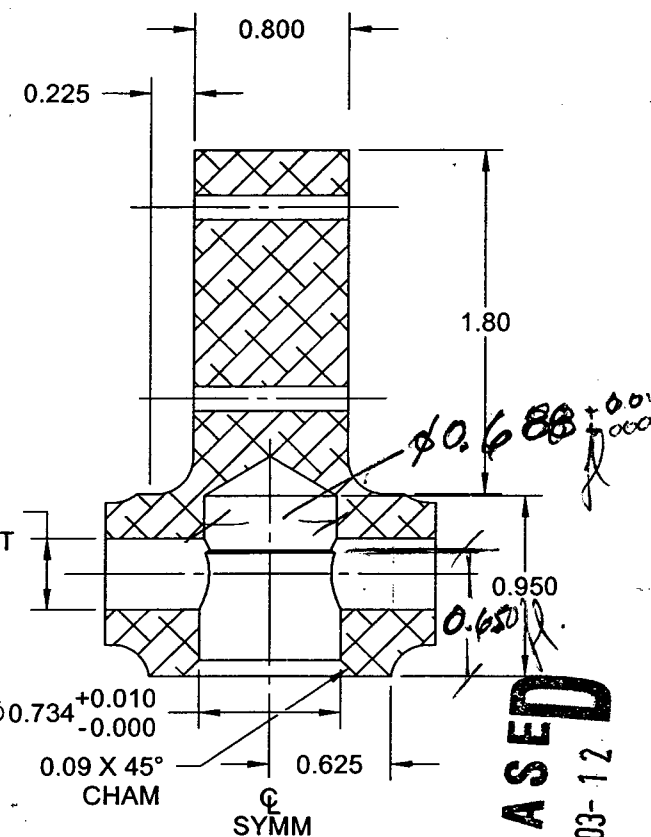
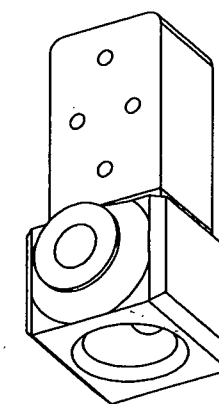
57064



**D3911-1 BASKET INSTL STUD (LOWER)**



**D3911-3 AFT EYEBOLT RECEIVER**



**SECTION A-A**

**NOTES:**

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs  
-3: 0.74 lbs

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2010-03-12